

# Work Order ID 55143



Page 1

January 7, 2010 8:43:47 AM

Item ID: D3281-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Floor Protector, Aft LH

Start Date: 1/1/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 1/01/2010 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

*PS*

Date: 10-1-07

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3281

Rev D

100

0.00



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Cut Blanks

*BB*  
10/01/21  
X10

110

0.00



THERMOFORMING MACHINE

Thermoform

Memo

0.00

Thermoforming Machine

Thermoform as per Dwg. D3281 and Folio FTA 009 ☐ Dwg. Rev.

☒ Folio Rev.

*BB*  
10/01/21  
X10

120

6.00



QC2- Inspect parts off machine FAI/FAIB


QC

Memo

0.00

Quality Control

*BB*  
10/01/21  
X10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10.01.21	130	ACCEPTABLE TO CUT 0.95" HIGH. LEAVE OUT BEVEL.				 10.01.21 PC AS 142		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

\_\_\_\_\_

January 7, 2010 8:43:47 AM

**Accept**

**Setup**   **Start**

**Stop**

**Cust Item ID:****Customer:**

**Reference:**

Run Start

**Approvals:** \_\_\_\_\_ **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

**Stop**

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Insp.  
Stamp**

0.00

0.00

## Memo

### Trim to Finished Dimensions

0.00

0.00

## Memo

10/01/21  
(KLB)

6.00

6.63

## Memo

### Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 55143**

Page 3

January 7, 2010 8:43:47 AM

Item ID: D3281-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Floor Protector, Afr LH

Start Date: 07/01/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging									
170		0.00							
	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

10-1-27 (100) SP

10/01/27 HJ  
MF 10-1-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

January 7, 2010 8:43:52 AM

Page 1

Work Order ID: 55143



Parent Item: D3281-3



Parent Item Name: Floor Protector, Aft LH

Start Date: 07/01/2010

Required Date: 15/01/2010

Comments: IPP Rev: ☐ 04.07.01 ☐ New issue ☐ KJ/JLM  
IPP Rev: ☒ 07.08.07 Thermoform in house DL  
IPP Rev: ☐ 08.02.06 To reflect updated Dwg. DL  
IPP Rev: ☒ 08.04.15 Material Change DL

Start Qty: 10.00

Required Qty: 10.00

MLEXS.093-F6006-02

Purchased

No

100

sf

1,376.930 43.3300



GE PLASTICS LEXAN SHEET

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

1376.93

106751

6.26

110877

1370.67

B  
10/01/21  
X10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>BART AEROSPACE LTD</b>		<b>Work Order:</b>	55143
<b>Description: Floor Protector, AR LH</b>		<b>Part Number:</b>	B3281-3
<b>Inspection Dwg: D3281 Rev: D</b>		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

#### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material Imperfections such as bumps, cracks, voids, scratching	✓			

<b>Measured by:</b>	DL	<b>Date:</b>	10/01/21
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#### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
17.8	+/-0.100	17.75"	✓			
17.1	+/-0.100	17.1"	✓			
14.3	+/-0.100	14.3"	✓			
0.95	+/-0.030	0.97"				
0.25	+/-0.030					
3.1	+/-0.100					
0.060	Min	0.0604	✓			
0.070	Min	0.079"	✓			

<b>Measured by:</b>	DL	<b>Date:</b>	10/01/21
<b>Audited by:</b>	JB	<b>Date:</b>	10/01/25
<b>Prototype Approval:</b>	N/A	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL	
C	08.09.12	Tolerance revised for 0.070 dimension	KJ/DL	

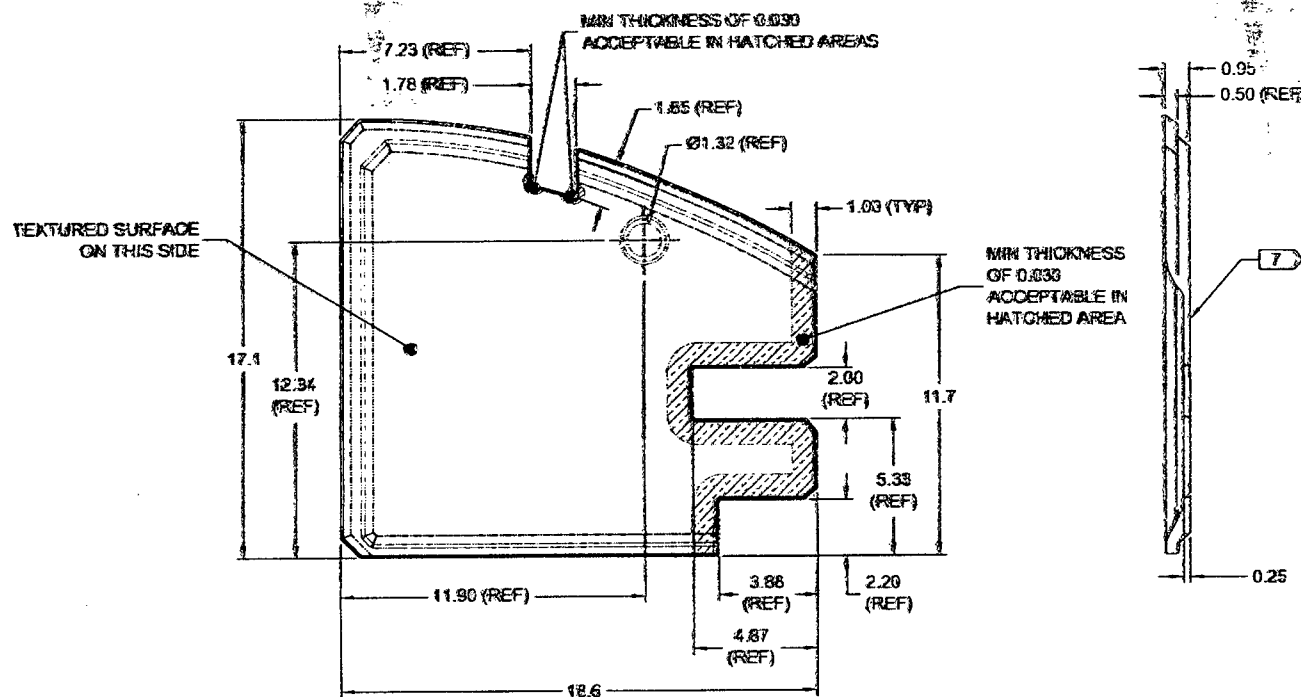
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

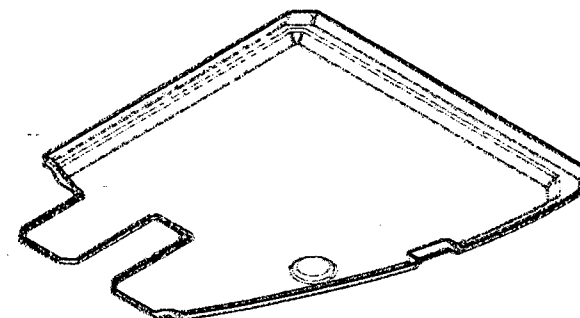
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3281-1 FLOOR PROTECTOR**



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. **55143**  
**BS 10-1-07**

**RELEASED**  
**105-0411 WPD**

**31-1 NOTES:**  
HERMOFORM WITH MOLD D3281-1T1 PER DART QSI 022; TRIM AS SHOWN  
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED  
MATERIAL: LEXAN F6006, BLACK No. 701, 0.053" THICK  
(REF DART SPEC MLEXS.053-F6006-02)

FINISH: NONE  
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
UNITS: INCHES UNLESS OTHERWISE NOTED  
BREAK SHARP EDGES: 0.010 MAX  
IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-1" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS  
WEIGHT: 0.95 lb

B	THICKNESS 0.033 WAS 0.125, MIN THICKNESS 0.070 WAS 0.060, P/N AND B/N ID WITH VIBRATING STYLUS (ZN A7-1, A7-2, A7-3, A7-4); D3281-4 NOW ON PAGE 4; CORRECT WEIGHTS (ZN A8-1, A8-2, A8-3, A8-4)	PH	08.05.28
C	UPDATE DWS TO MATCH PARTS: COLOUR Z01 WAS 700; GENERAL UPDATE	LE	07.10.08
B	NOW LEGEND, DIMS AS MANUFACTURED	CP	05.11.25
A	NEW ISSUE	CP	04.05.08
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
USE APPR.			
DATE	08.03.28		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3281** REV. ID  
SHEET 1 OF 4  
TITLE **FLOOR PROTECTOR** SCALE  
NTS

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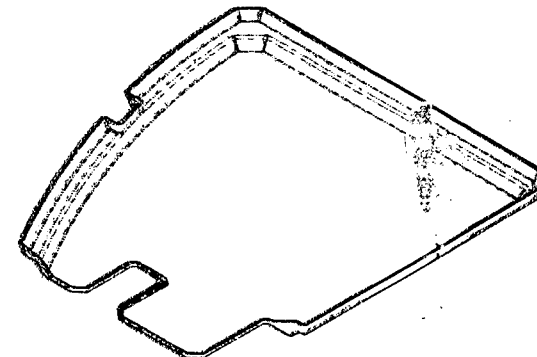
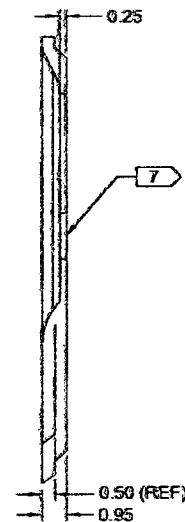
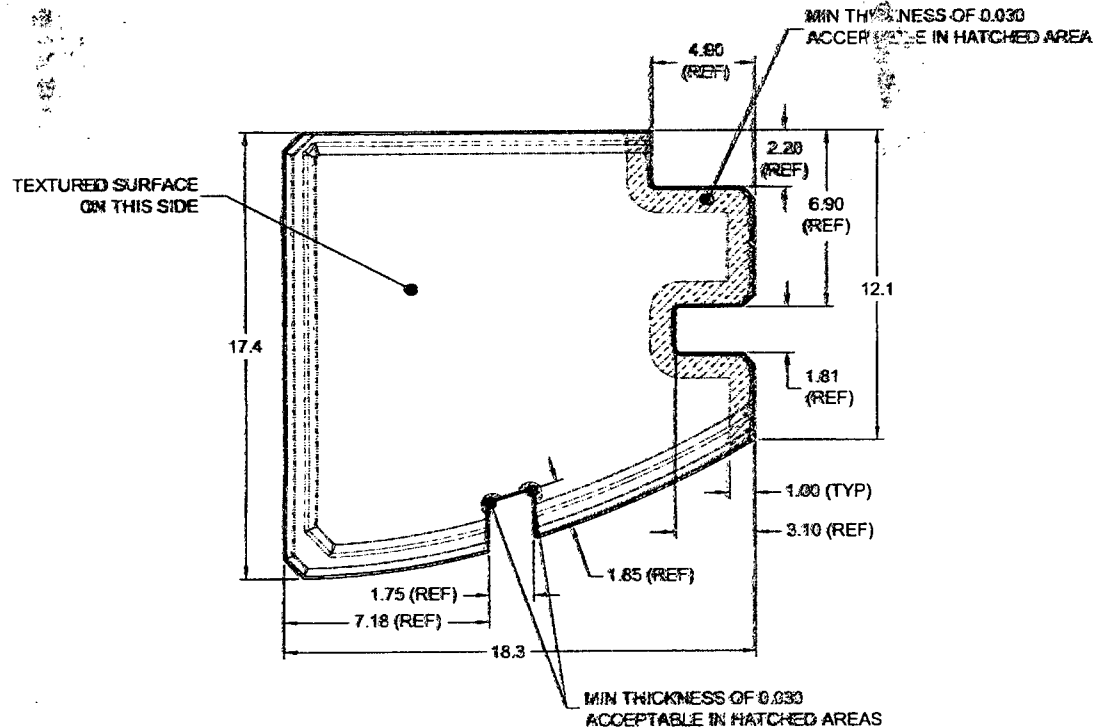
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



### D3281-2 FLOOR PROTECTOR

**1-2 NOTES:**  
HERMOFORM WITH MOLD D3281-2T1 PER DART QSI 022; TRIM AS SHOWN  
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED  
MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK  
(REF DART SPEC MLEXS.093-F6006-02)

FINISH: NONE  
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
UNITS: INCHES UNLESS OTHERWISE NOTED  
BREAK SHARP EDGES: 0.010 MAX  
IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-2" AND BATCH NUMBER "SXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS  
WEIGHT: 0.97 lb

**DART AEROSPACE LTD**

HAMMERSBURY, ONTARIO, CANADA

DESIGN		DART AEROSPACE LTD	
DRAWN		HAMMERSBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3281	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		FLOOR PROTECTOR	NTS
DATE	08.03.28	<small>CONFIDENTIAL © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE BASIS OF CONDITION THAT IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, WITHOUT PERMISSION FROM DART AEROSPACE LTD.</small>	

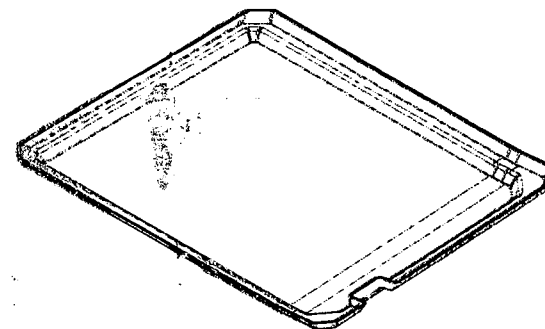
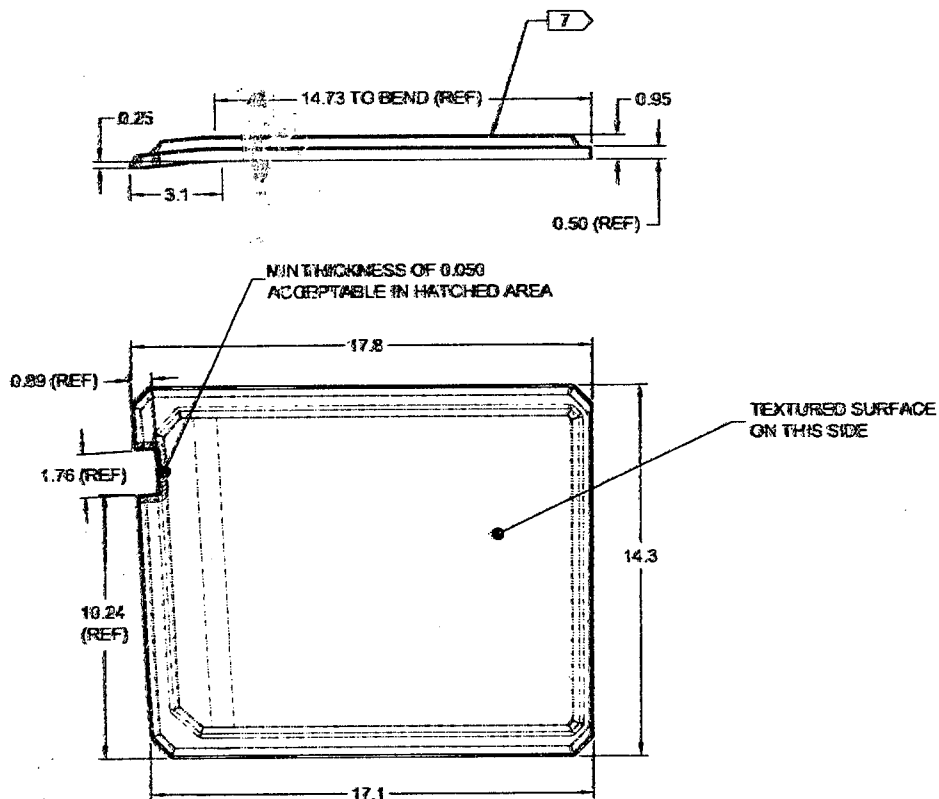
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



### D3281-3 FLOOR PROTECTOR

#### D3281-3 NOTES:

HERMOFORM WITH MOLD D3281-3T1 PER DART QSI 022. TRIM AS SHOWN  
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED  
MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK  
(REF DART SPEC MLEXS.093-F6006-02)

FINISH: NONE

TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

UNITS: INCHES UNLESS OTHERWISE NOTED

BREAK SHARP EDGES: 0.010 MAX

IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-3" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS

WEIGHT: 0.87 lb

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RE	DRAWING NO.	REV. D
CHECKED	JS	D3281	SHEET 3 OF 4
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DATE	08.03.28	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

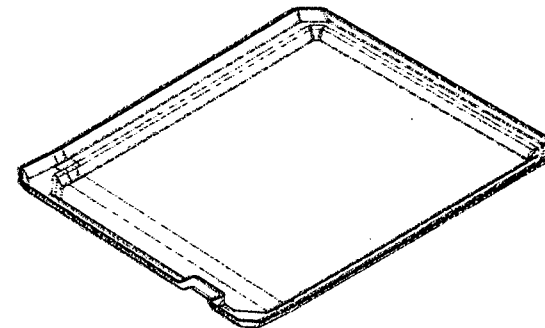
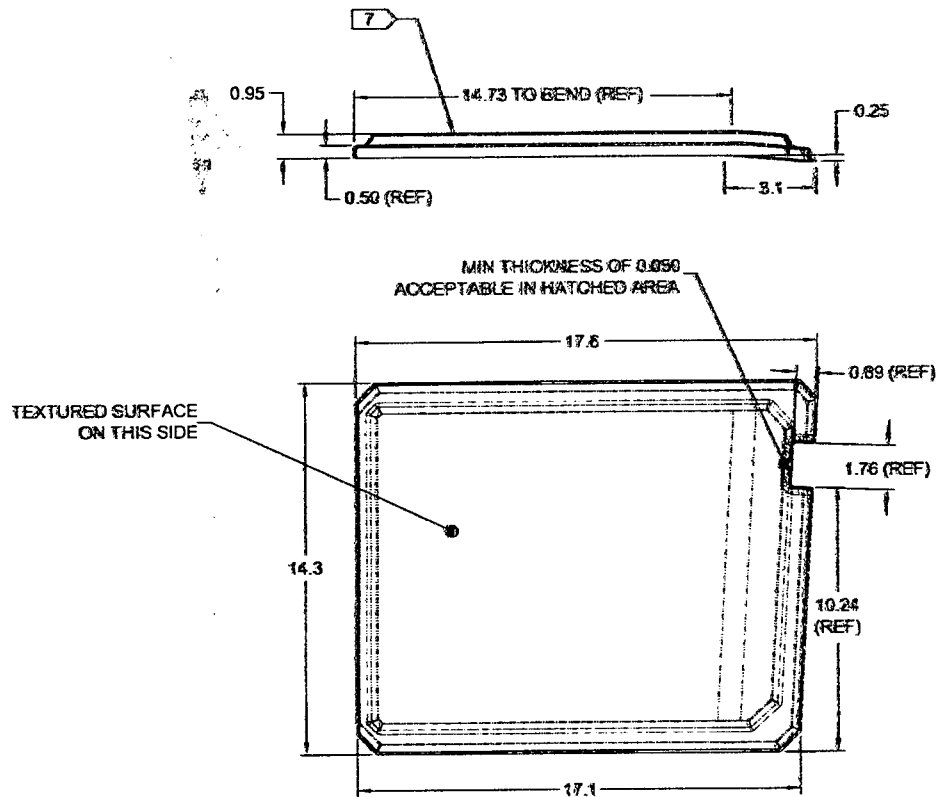
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





# **D3281-4 FLOOR PROTECTOR**

## **NOTES:**

HERMOFORM WITH MOLD D3281-4T1 PER DART QSI 022; TRIM AS SHOWN  
 MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED  
 MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK  
 (REF DART SPEC MLEXS.093-F6006-02)

FINISH: NONE

TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

UNITS: INCHES UNLESS OTHERWISE NOTED

BREAK SHARP EDGES: 0.010 MAX

IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-4" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS

WEIGHT: 0.87 lb

**DART AEROSPACE LTD**  
 HAWKESBURY, ONTARIO, CANADA

DESIGN	40	DRAWING NO.	REV. 0
DRAWN	BA	D3281	SHEET 4 OF 4
CHECKED	DF	TITLE	SCALE
MFG. APPR.	DF	FLOOR PROTECTOR	NTS
APPROVED	DF		
DATE	08.03.28		

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries